

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015288**Date Inspected:** 02-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Zhang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 9AW-9BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045196 performing Shielded Metal Arc Welding process for weld 013 located on PCMK EP124-001. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-b-u2-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045221 performing Shielded Metal Arc Welding process for weld 020 located on PCMK DP684-001. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-u3b.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045133 performing Shielded Metal Arc Welding process for weld 019 located on PCMK DP671-001. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-u3b.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067588 performing Shielded Metal Arc Welding process for weld 020 located on PCMK DP671-001. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-u3b.

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing Ultrasonic Inspection for the weld between side panel and bottom panel (cross beam side) of OBG segment 9AW at 8CW.

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing Ultrasonic Inspection for the weld between side panel and edge panel (Counter weight side) of OBG segment 9AW at 8CW.

OBG SEGMENT 9BE-9CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220067 performing Shielded Metal Arc Welding process for weld 028 located on PCMK SEG052A. ZPMC QC Mr. Wu Zhi Zhang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-u4b-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048659 performing Shielded Metal Arc Welding process for weld 021 located on PCMK SEG052A. ZPMC QC Mr. Wu Zhi Zhang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-u2-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054467 performing Shielded Metal Arc Welding process for weld 013 located on PCMK SEG054A. ZPMC QC Mr. Wu Zhi Zhang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-u2-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC QA Inspector performing Magnetic Particle Inspection for the deck panel splice weld between OBG segment 9CE and 9BE.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

Only general conversation was held between QA and QC

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant
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Quality Assurance Inspector

Reviewed By:	Peterson,Art
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QA Reviewer
